

BLUE

Work Order ID 60997

August 5, 2010 8:11:40 AM



Page 1

Item ID: D3394-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 03/08/2010 Start Qty: 24.00



Cust-Item ID:

Required Date: 09/08/2010 Req'd Qty: 24.00

Customer:

Reference:

10-08-05

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3394 DEO

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank to .850"

28 10/08/05

24

0

103

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

28 10/08/05

24

0

115

0.00



QC

Memo

0.00

Quality Control

QC2

28 10/08/05

24

0

Work Order ID 60997

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Page 2

Item ID:	D3394-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Lug Assembly					
Start Date:	03/08/2010	Start Qty: 24.00		Cust Item ID:		
Required Date:	09/08/2010	Req'd Qty: 24.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
117 		0.00							
QC	Memo	0.00				24			
Quality Control	QC8								
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
145 		0.00							
SprayPaint	Memo	0.00							
Spray Painting	spray paint Delfleet Blue								
	primer B 116 191								
	Delfleet Blue B 115 509								
	Delfleet clear B 113 314								

ml 10 08 09 24

10 09 03 24

Work Order ID 60997

August 5, 2010 8:11:40 AM



Page 3

Item ID: D3394-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 03/08/2010 Start Qty: 24.00



Cust Item ID:

Required Date: 09/08/2010 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

146

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

ml 10 09 07 24'

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3394

8/10/09/07 24'

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/09/08

counts

24

Work Order ID 60997

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Page 4

Item ID: D3394-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug Assembly

Start Date: 03/08/2010 Start Qty: 24.00

Cust Item ID:

Required Date: 09/08/2010 Req'd Qty: 24.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 57420

0.00



Packaging

Memo

0.00

Packaging

6/12/10 (24)

200

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/08 MF

MF

10-9-8

Picklist Print

August 3, 2010 3:31:53 PM

Page 1

Work Order ID: 60997

Parent Item: D3394-043

Parent Item Name: Lug Assembly



Start Date: 8/03/10

Required Date: 8/09/10

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev: A New Issue 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423		Manufactured	No			110	f	382.0476	0.07	1.768421			
-------	--	--------------	----	--	--	-----	---	----------	------	----------	--	--	--



Lug Extrusion

Location

Loc Qty

Loc Code

MAT06

382.0475795

43722

180

45800

202.047579

D3394-3P



Lug

MS35489-93



GROMMET

Purchased

No

170

Each

0.0000

1

24



1.7685

8/10/08/05

24

7+ scrap 6"

Purchased

No

100

Each

80.0000

2

48



8/10/09/07

Location

Loc Qty

Loc Code

ST293

80

114341

80

48

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

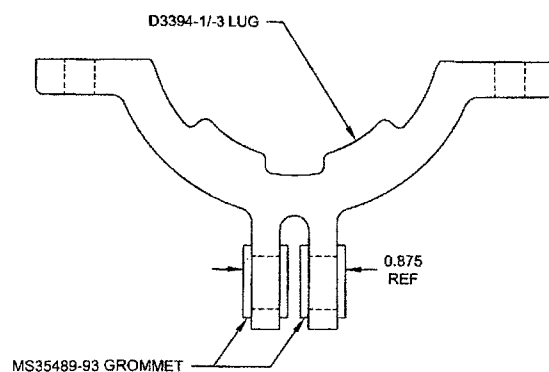
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

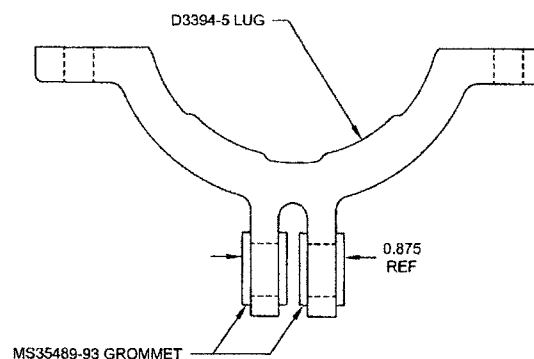
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3394-041	LUG ASSEMBLY
	X		D3394-043	LUG ASSEMBLY
		X	D3394-045	LUG ASSEMBLY
1			D3394-1	LUG
	1		D3394-3	LUG
		1	D3394-5	LUG
2	2	2	MS35489-93	GROMMET



D3394-041/-043 LUG ASSEMBLY



D3394-045 LUG ASSEMBLY

NOTES:

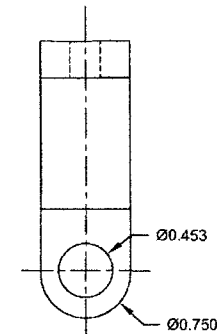
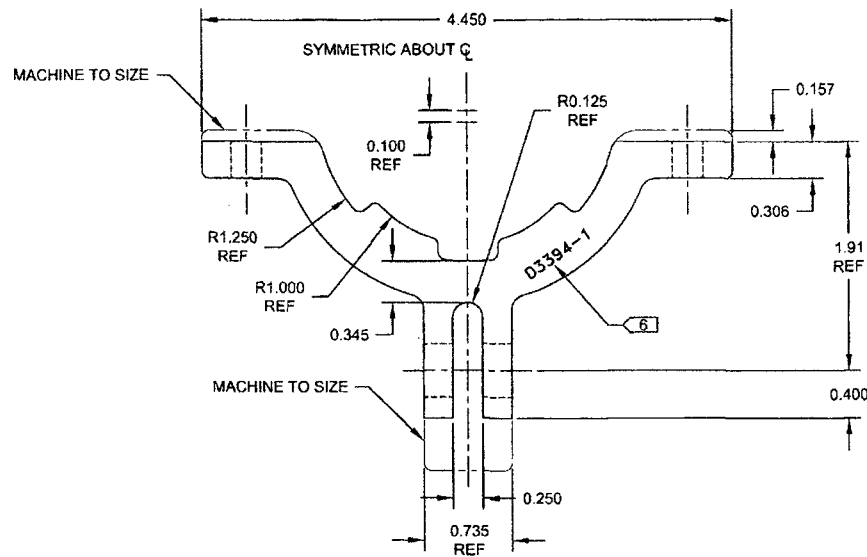
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.20 lbs APPROX

B	ADDED -045, SHT 4 ADDED FILLETS IN SECTION A-A. SEE PAR 152	AJS	09.04.02
A	NEW ISSUE	PH	05.02.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
DATE	09.04.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL OR GOVERNMENT TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD.	

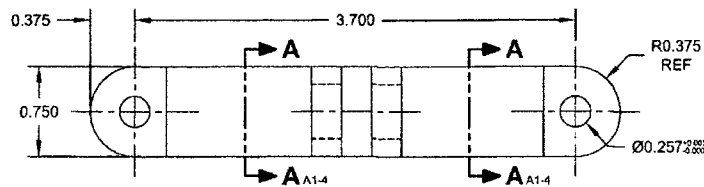
DEO ATTACHED

RELEASED
09/16/15 NDC

w/o 60997



w/o 60997



D3394-1 LUG

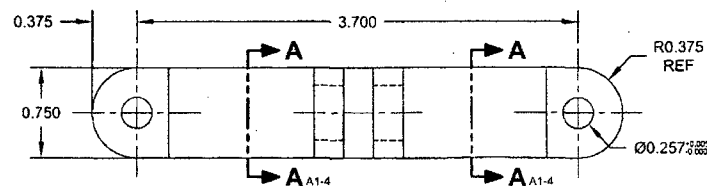
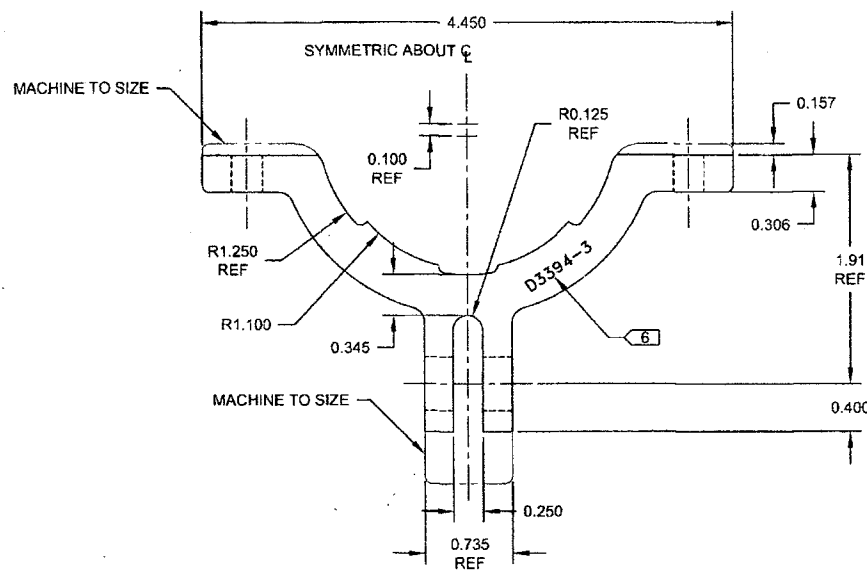
NOTES:

- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION.
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

DEO ATTACHED

RELEASED
09/26/25-1

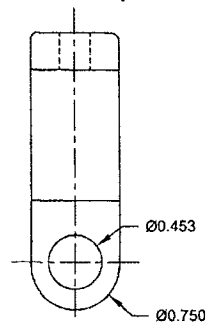
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 2 OF 4
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DE APPR.		LUG	NTS
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D3394-3 LUG

NOTES:

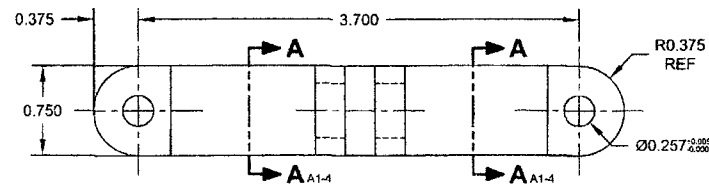
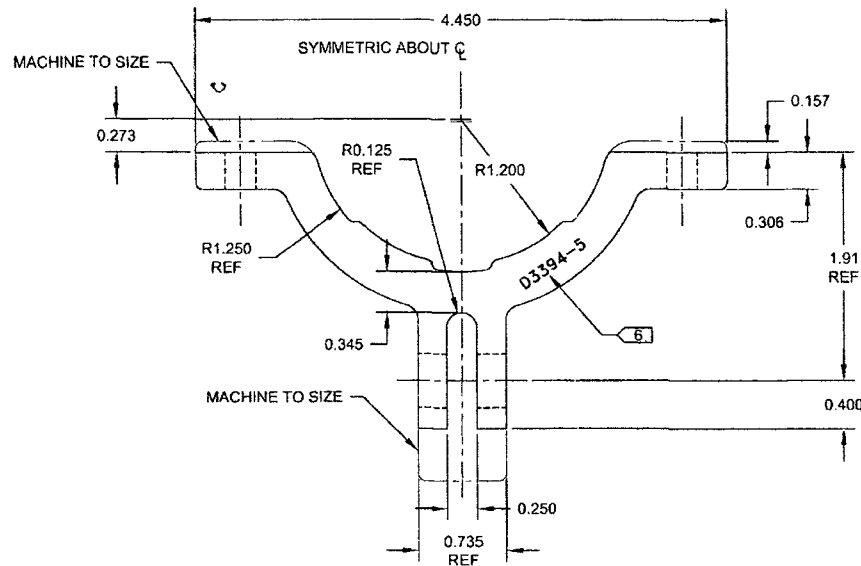
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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs



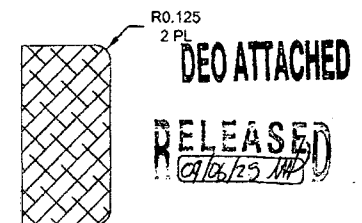
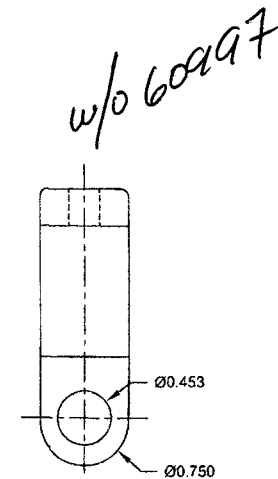
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RELEASED
09/25/14

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
DATE	09.04.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD	



D3394-5 LUG



SECTION A-A
B5-2
B4-2
B5-3
B4-3
B5-4
B4-4

NOTES:

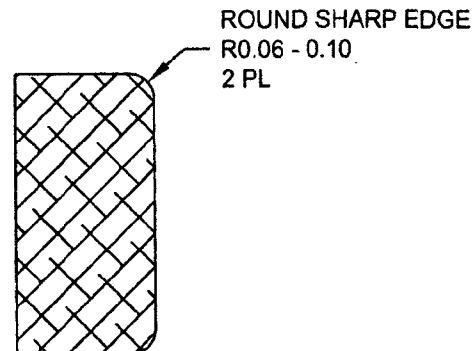
- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	A/S		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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DRAWING NO. D3394	TITLE LUG	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3394-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 09.11.04	DATE 09.11.04	DATE 09.11.04	DATE 09.11.04	DATE 09.11.04			

SHEET 4 ZONE A,1 MODIFY SECTION A-A AS SHOWN:

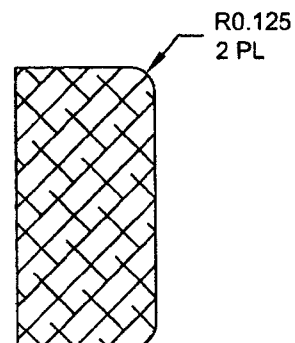
IS:



SECTION A-A

w/o 60997

WAS:



SECTION A-A

RELEASED
2009-11-25
WAD

REASON: DRAFTING ERROR

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